

## **Module & Contact Installation/Removal — Section 1**

### **Twin Access Contact (TAC)**

#### **Receiver Wiring Module and ITA Module Installation/Removal Instructions**

P/N 510 133 109 (380 signal wiring contacts)

P/N 510 133 110 (228 signal wiring contacts/12 coaxial or power wiring contacts)

P/N 510 133 111 (180 signal wiring contacts/10 coaxial (75 OHM) wiring contacts)

P/N 510 133 112 (46 coaxial or power wiring contacts)

P/N 510 134 104 (ITA, 46 positions, coaxial or power wiring contacts)

P/N 510 134 101 (ITA 380 signal wiring contacts)

P/N 510 134 102 (ITA, 228 positions/12 coaxial/power wiring contacts)

P/N 510 134 103 (ITA, 180 positions, 10 coaxial (75 OHM)

#### **PARTS/TOOLS REQUIRED:**

5/64 Allen Hex Wrench

3/32 Allen Hex Wrench

#### **INSTRUCTIONS:**

##### Receiver

1. Place the module on the rear of the Receiver Module aligning the locating bosses on the modules with the appropriate holes in the Receiver Module.
2. Install the modules such that the numbers can be read from top to bottom, making them right side up.
3. Insert the #2 Socket Head Cap Screws, .50" length, in the module fastening holes.
4. Using a 5/64 Allen Hex Wrench, tighten the top screw 1 to 2 full revolutions, while lightly applying pressure against the face of the module. 5. Maintain this pressure while tightening the bottom screw 1 to 2 full revolutions.
6. Repeat this sequence until the module is seated. Torque the screw until it is 4 to 5 inch pounds.
7. To remove, loosen the top screw 1 to 2 full revolutions. Loosen bottom screw 1 to 2 full revolutions. Repeat this sequence until the module is separated from the Receiver.

**NOTE:** It is important to alternate the tightening/loosening of module screws.

##### ITA

1. To install Module into ITA, place module in the ITA with the screening facing upward. Align top of the module with the designated top of the ITA and the locating bosses on the module with the appropriate holes in the ITA.
2. The modules should be installed such that the numbers can be read from top to bottom.
3. Insert the #4 Socket Head Cap Screws, 0.50" length, in the module fastening holes.
4. Using a 3/32 Allen Hex Wrench, tighten the top screw 1 to 2 full revolutions, while pushing lightly against the face of the module.
5. Maintain this pressure while tightening the bottom screw 1 to 2 full revolutions.
6. Repeat this sequence until the module is seated. Torque the screw until it is 8 to 10 inch pounds.

To remove, loosen the screws until the module is separated from the ITA.

